

Work Order ID 67262

Monday, March 14, 2011 10:59:53 AM

BLUE



Page 1

Item ID: D2939-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 3/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

SA 11/3/29

4

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SA 11/3/29

4

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

SA 11/3/29

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67262

Monday, March 14, 2011 10:59:53 AM



Page 2

Item ID: D2939-1

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Revision ID:

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Item Name: Saddle LH In, 206

Start Date: 3/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

amr 11/03/30

4

~~0~~

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

H BR 11-3-30.

Hand Finishing

155

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

ml 11 04 07 (4)

Spray Painting

Spray Painting:
prime grey B: 115967
spray paint delfleet blue B: 115985
clear delfleet B: 117113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67262

Page 3

Monday, March 14, 2011 10:59:53 AM

Item ID: D2939-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 3/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish

0.00



QC14

QC

Memo

0.00

Quality Control

BT 11-04-08 (x4)

170 Identify as per dwg & Stock Location: 42

0.00



Packaging

Memo

0.00

Packaging

11/4/11 SL 140

180 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/12 J

11.04.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 14, 2011 10:59:50 AM

Page 1

Work Order ID: 67262



Parent Item: D2939-1



Parent Item Name: Saddle LH In, 206


Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B000.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001  Saddle Billet		Manufactured	No			100	Each	56.0000	1	4		3/13/29	

Location

Loc Qty

Loc Code

MAT40

56

64777

36

66965

20

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	167262
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

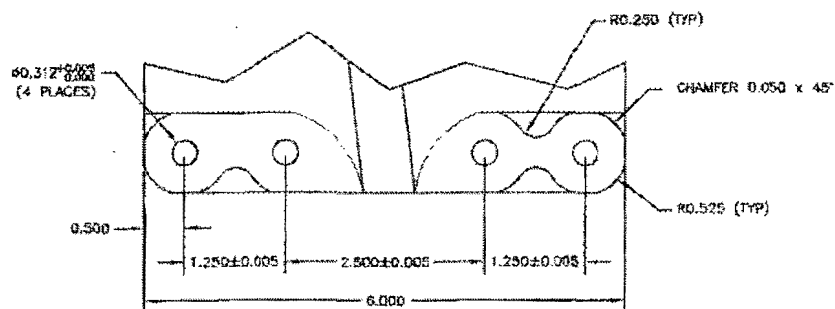
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.132	.134	.134	.134		
B	0.100	0.140		.134	.135	.135	.135		
C	0.100	0.140		.126	.125	.126	.126		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.110	.110	.111	.110		
O	0.540	0.560		.548	.548	.548	.548		
P	0.490	0.510		.495	.498	.435	.498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.738	2.738	2.738	2.738		
S	0.240	0.270		.250	.250	.250	.250		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.317	.317	.317	.317		
X	1.250	1.270		1.260	1.261	1.260	1.261		
Y	1.565	1.585	DT8695 A/B	1.575	1.520	1.575	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

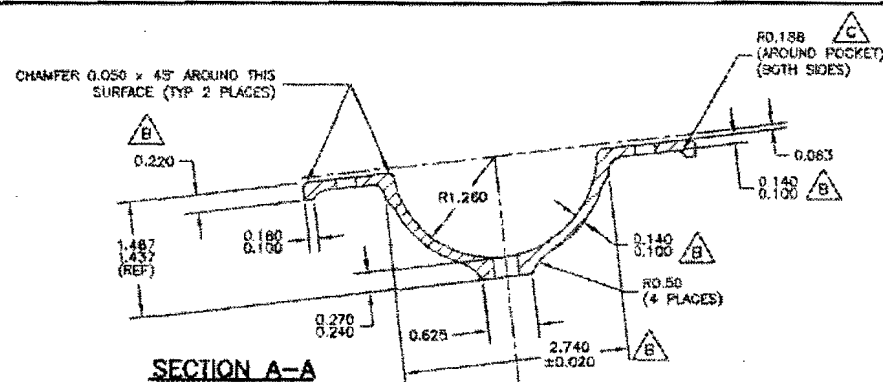
Measured by:	JA
Date:	11/3/29

Audited by:	cmf
Date:	11/03/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	SA

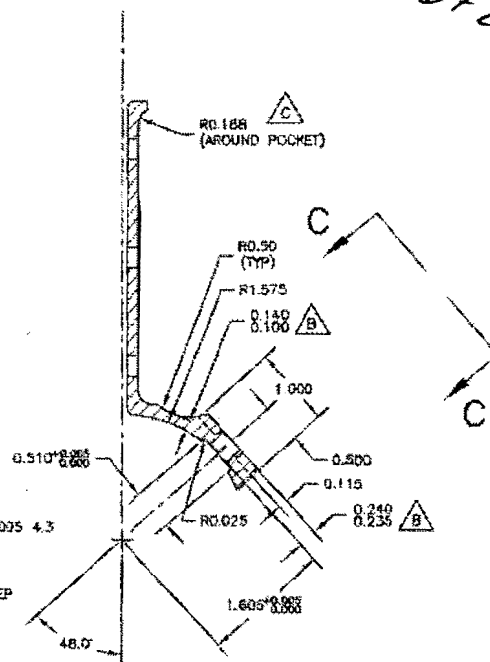


VIEW C-C



SECTION A-A

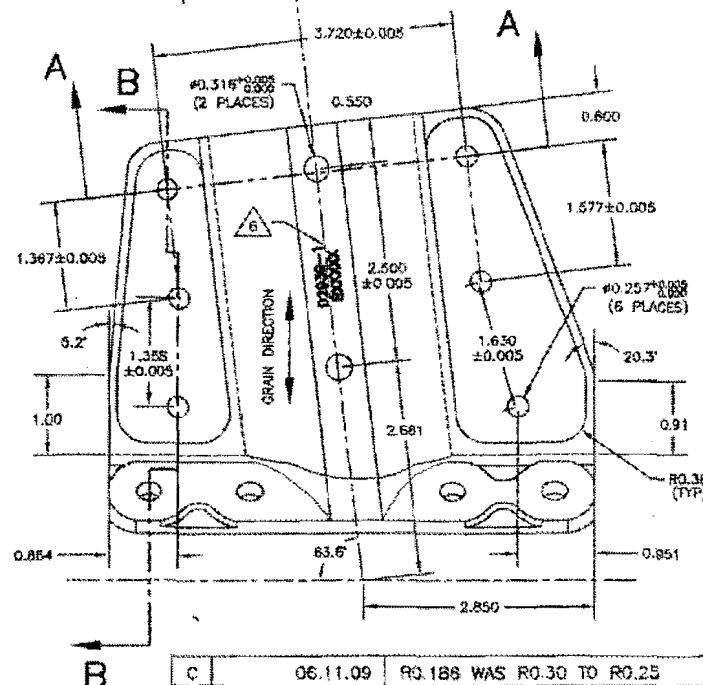
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)



SECTION B-B

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (00-A-250/12)
(MAKE FROM D6101-001 SADDLE BULLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 035 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 019 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE
		SCALE
		2:1

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DART DART AEROSPACE USA, INC.
BELLDALE, IN

DRAWING NO. D2939

REV. C
SHEET 1 OF 1

